

Work Order ID 57072

Saturday, March 20, 2010 9:32:52 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long basket Ass'y.-350

Start Date: 3/22/2010 Start Qty: 1.00



Cust Item ID:

Customer:

PRELIMINARY ISSUE

Required Date: 3/31/2010 Req'd Qty: 1.00

Reference:

Run Start



Approvals: Process Plan: MF

Date: 10-3-00 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3913

PA1 Rev A

100

Weld per dwg A/R S.S. rod Batch: H1092B 0.00

Large Fab

Large Fab

Large Fab

Memo

0.00

1- assemble ribs, weld as per dwg D3913 - PD
inspect before welding mesh
2- tack weld mesh on basket as per dwg D3913 - FL
3- weld hinge (3) and Mounting brackets as per dwg D3913
take lid to locate hinge and bracket

PD 10.04.08

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo

0.00

Quality Control

lpl 10.04.08

Pho ->

W/O: 57072		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/12		Perm. Change change header Box to Rev A	AA	10.04.12			S 10/04/12

Part No: D3913-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D3913-041

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Setup Start



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Item Name: Long basket Ass'y, 350

Start Date: 3/22/2010 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Subtotal +1
to Rev A Day

Memo

130



Powdercoat

Powder Coating

+pressure wash
White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

M113170

0.00

0.00

Memo

U- Plug holes prior to

= 24 10/04/08

(x1) Ø

1ST COAT:

START TIME: 1:45pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 2:15pm

***** 2nd coat if necessary *****

2ND COAT:

START TIME: 2:30pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:00pm

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

BR 10-4-8

150

Assemble as per dwg

0.00

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

8/5/04/12

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8 10/04/12
to Rev A Day.

X0

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: GA

0.00



Packaging

W/05741
Memo

0.00

Packaging

3/10/04/12 0

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12 JD

3/10-4/12
(1)

POSITIVE RECALL
EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 57072

Parent Item: D3913-041

Parent Item Name: Long basket Ass'y, 350













Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 3/22/2010

Required Date: 3/31/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status																														
D2581  Mounting Bracket		Manufactured	No			100	Each	35.0000	1.0000																																	
<table><tr><th><u>Warehouse</u></th><th><u>Loc Qty</u></th><th><u>Loc Code</u></th></tr><tr><td><u>Location</u></td><td></td><td></td></tr><tr><td>Main Warehouse</td><td></td><td></td></tr><tr><td>WA</td><td>35</td><td></td></tr><tr><td>46086</td><td>2</td><td></td></tr><tr><td>48428</td><td>1</td><td></td></tr><tr><td>50872</td><td>1</td><td></td></tr><tr><td>51120</td><td>2</td><td></td></tr><tr><td>51745</td><td>2</td><td></td></tr><tr><td>55918</td><td>27</td><td></td></tr></table>													<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>	<u>Location</u>			Main Warehouse			WA	35		46086	2		48428	1		50872	1		51120	2		51745	2		55918	27	
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>																																								
<u>Location</u>																																										
Main Warehouse																																										
WA	35																																									
46086	2																																									
48428	1																																									
50872	1																																									
51120	2																																									
51745	2																																									
55918	27																																									
D3913-1  Rib		Manufactured	No			100	Each	0.0000	1.0000																																	
D3913-15  Wide Handle Plate		Manufactured	No			100	Each	0.0000	1.0000																																	
D3913-3  Rib		Manufactured	No			100	Each	0.0000	1.0000																																	
D3913-7  Rib		Manufactured	No			100	Each	0.0000	2.0000																																	
D3913-9  Rib		Manufactured	No			100	Each	0.0000	1.0000																																	

PD 10.04.03

B57286 PD 10.04.03

B57079 PD 10.04.03

B57287 PD 10.04.03

B57082 PD 10.04.03

~~B57287~~ B57288 PD 10.04.03

PD 10.04.05

B57286

PD 10.04.05

B57079

PD 10.04.05

B57287

PD 10.04.05

B57082

PD 10.04.05

~~B57082~~

B57288

PD 10.04.05

Dart Aerospace Ltd

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Parent Item Name: Long basket Ass'y, 350

Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3916-041 		Manufactured	No			100	Each	0.0000	3.0000 2			
Rib Assembly										BS6941-1	PD 10.04.05	
D3916-5 		Manufactured	No			100	Each	0.0000	2.0000 3			
Light Rib										BS7023	PD 10.04.05	
D4016-1 		Manufactured	No			100	Each	0.0000	1.0000 3			
Hinge Half, Base										BS6949	PD 10.04.07	
D4017-7 		Manufactured	No			100	Each	0.0000	1.0000			
Rib										BS7084	PD 10.04.07	
D4017-9 		Manufactured	No			100	Each	0.0000	2.0000			
Rib										BS7085	PD 10.04.05	
D4020-1 		Manufactured	No			100	Each	0.0000	1.0000			
Mesh (350 Basket Long, Base)										BS6988	PD 10-4-6	
D4020-11 		Manufactured	No			100	Each	0.0000	1.0000			
End Mesh, Basket										BS6990	PD 10.04.07	

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Dart Aerospace Ltd

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Parent Item: D3913-041

Parent Item Name: Long basket Ass'y, 350


Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 3/22/2010

Required Date: 3/31/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4021-1  Handle Plate		Manufactured	No			100	Each	3.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	3	
56044	3	

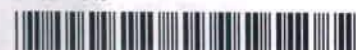
B57068 PD 10.04.07

D4034-041



Aft Upper Rib Assembly

D4034-043



Fwd Upper Rib Assembly

AN3-10A



Bolt

Manufactured	No		100	Each	0.0000	1.0000
Manufactured	No		100	Each	0.0000	1.0000
Purchased	No		150	Each	56.0000	6.0000

B56991 PD 10.04.05

B56991 PD 10.01.05

4/30/04/12

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST351	56	
111119	56	

6

Saturday, March 20, 2010 9:32:52 AM

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Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

Work Order ID: 57072

Parent Item: D3913-041

Parent Item Name: Long basket Ass'y, 350


Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 3/22/2010

Required Date: 3/31/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8  Washer		Purchased	No			150	Each	226.0000	1.0000			

NAS 1149 DV 832J
Per GST 17

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST347	226	
107091	9	
108335	11	
110382	48	
110917	3	
111578	15	
112385	140	

② Sp 10/04/12

D2931



Bumper

Manufactured No

150 Each 895.0000 1.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST504	895	
46064	895	

Sp 10/04/12

D4021-5



Blanking Plate

Manufactured No

150 Each 0.0000 1.0000

B57360 (2x)

2 Sp 10/04/12

Saturday, March 20, 2010 9:32:52 AM

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Page 4

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Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W3  Cherry Rivets		Purchased	No			150	Each	2,319.000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST321	2319	
102929	37	
104715	10	
106375	304	
107939	1000	
111636	968	

EP 10/04/12

MS21042L3  Nut	Purchased	No				150	Each	2,141.000	1.0000			
---	-----------	----	--	--	--	-----	------	-----------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST300	2141	
110844	35	
111274	27	
111668	58	
112314	285	
112385	16	
113523	20	
113537	700	
113644	1000	

EP 10/04/12

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149F0332P		Purchased	No			150	Each	1,110.000	12.0000			



WASHER



Handwritten signature
3/30/04/12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST275

1110

18057

1110

Handwritten number 12

Saturday, March 20, 2010 9:32:52 AM

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

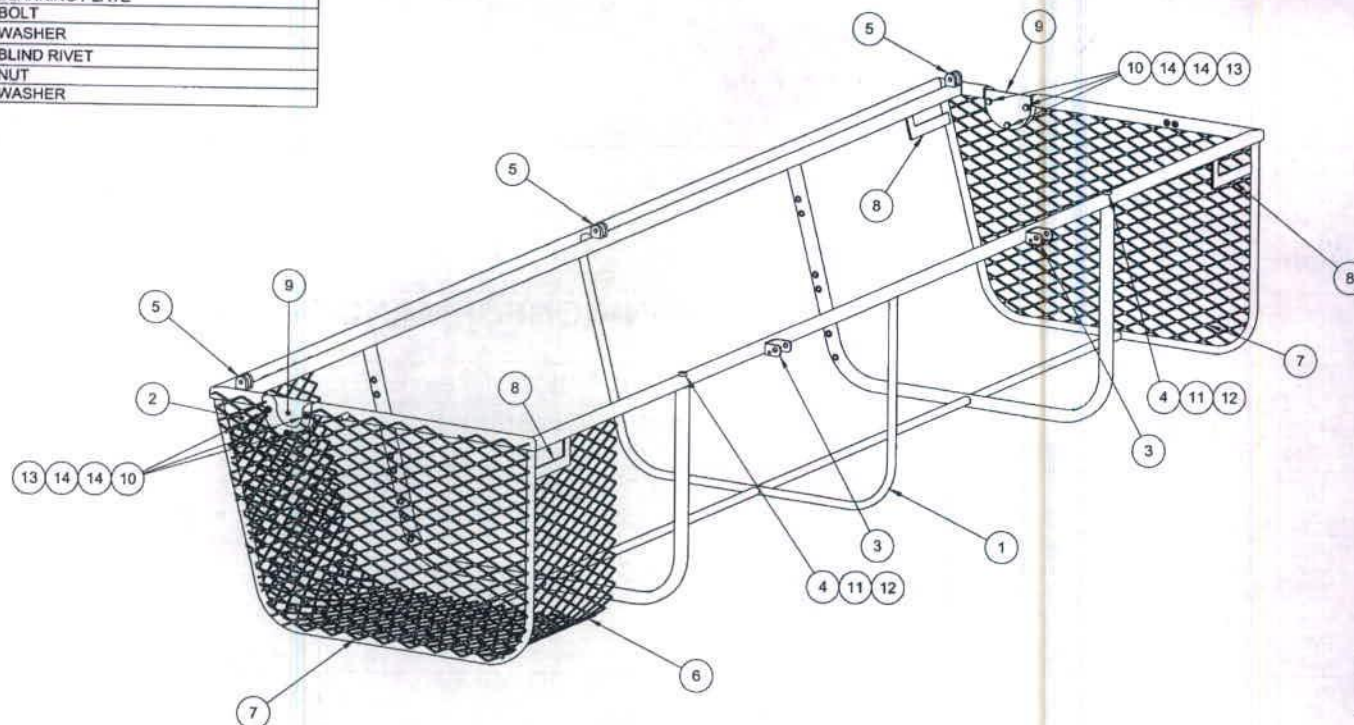
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20800AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

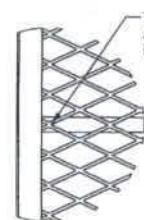
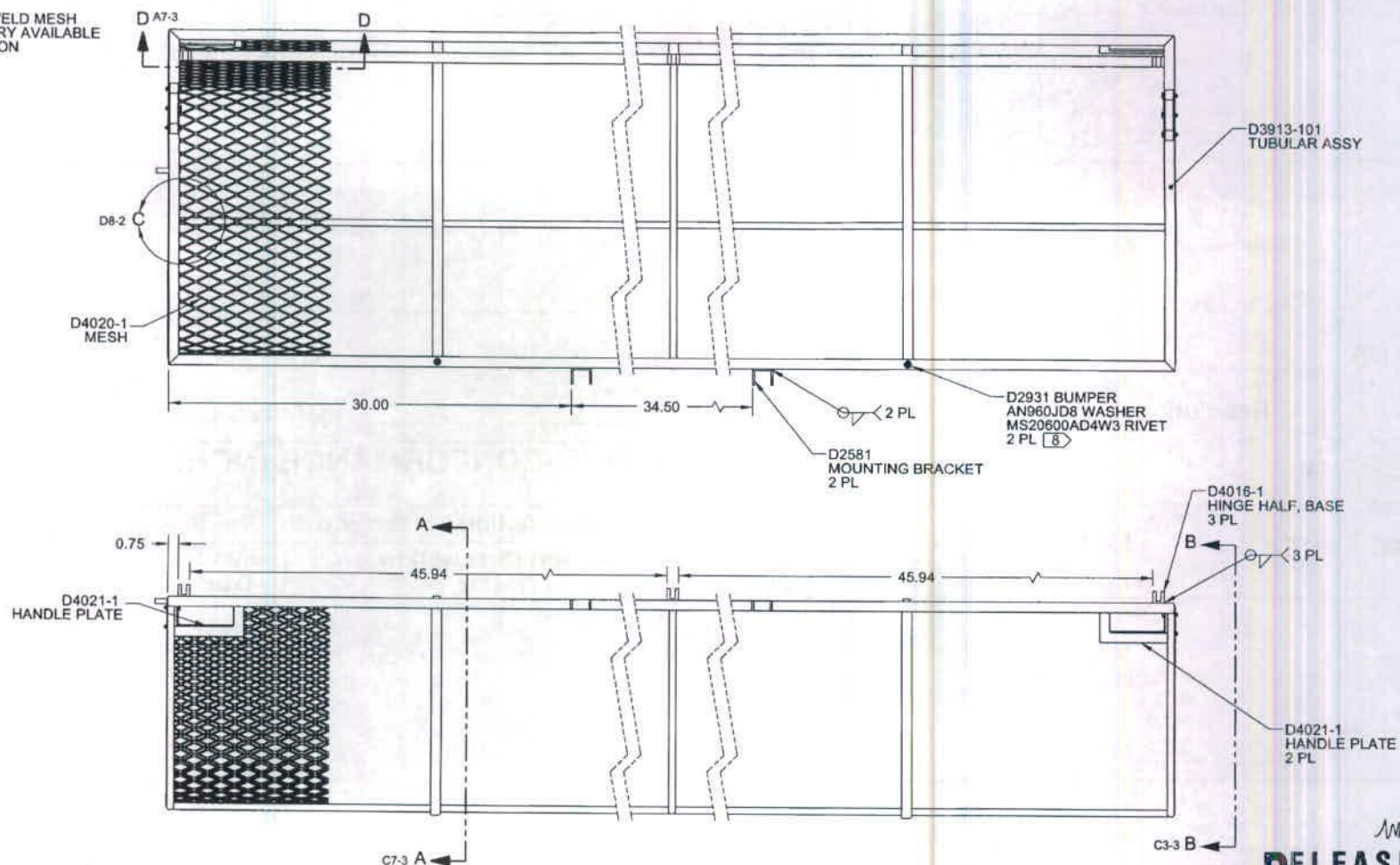
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NOTE: Date & initial all entries

57070

**DETAIL C** D7-2**D3913-041 LONG BASKET BASE ASSY (350)**
(MESH SHOWN LOCALLY FOR CLARITY)**RELEASED**
2010-03-27

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

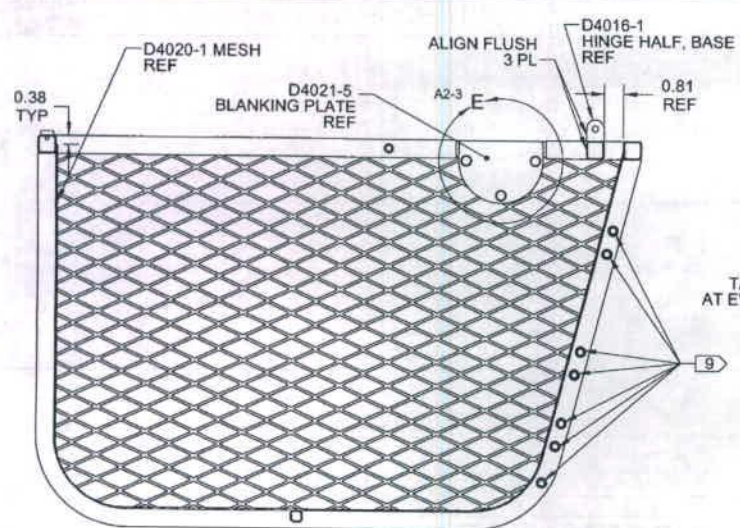
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

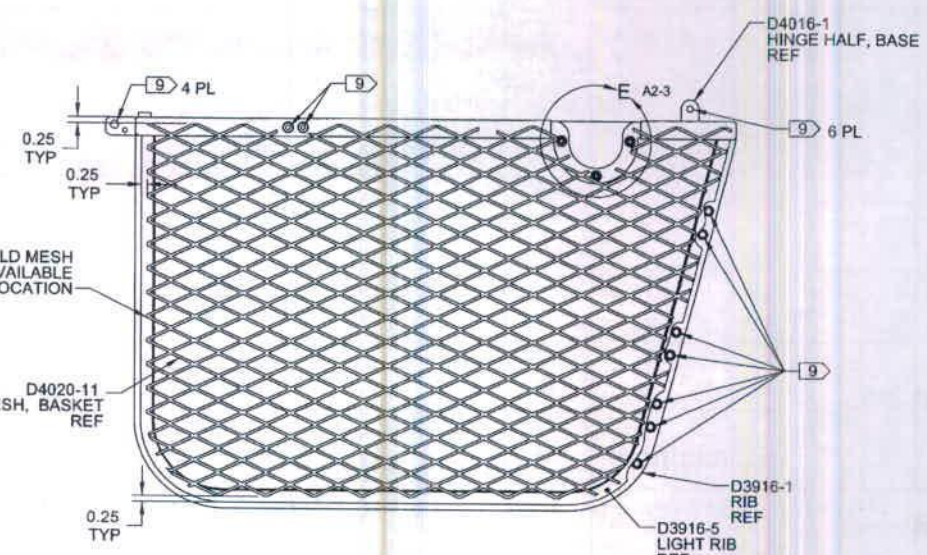
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

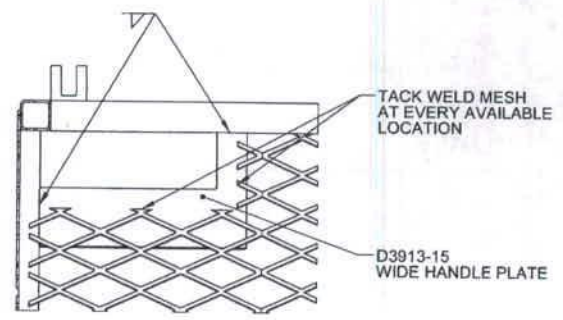
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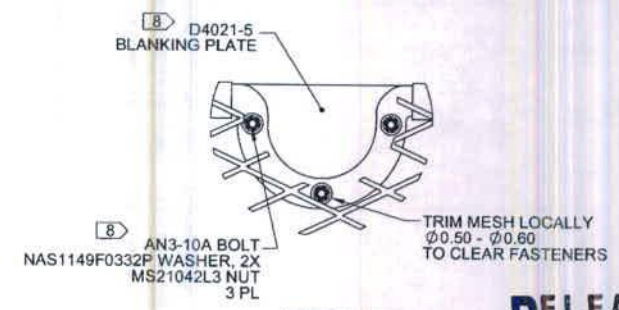
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
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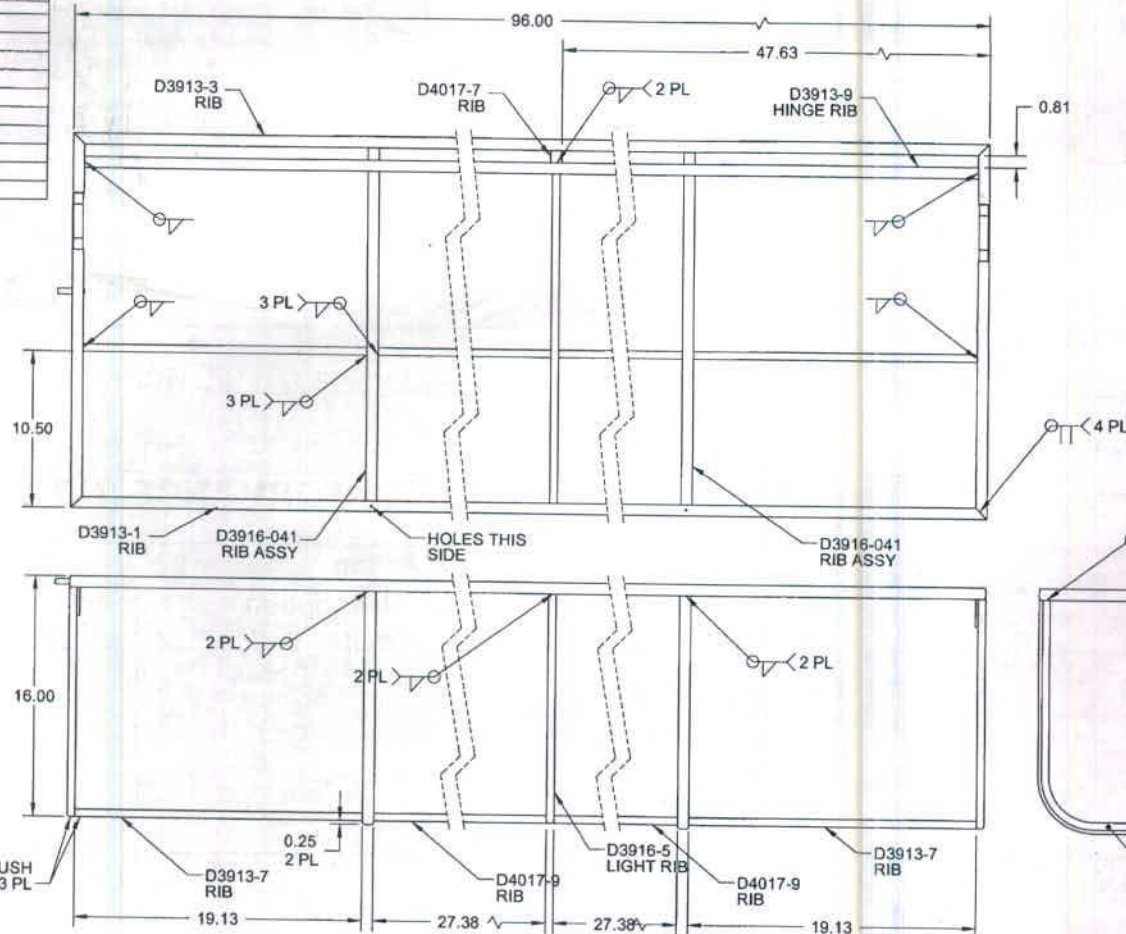
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

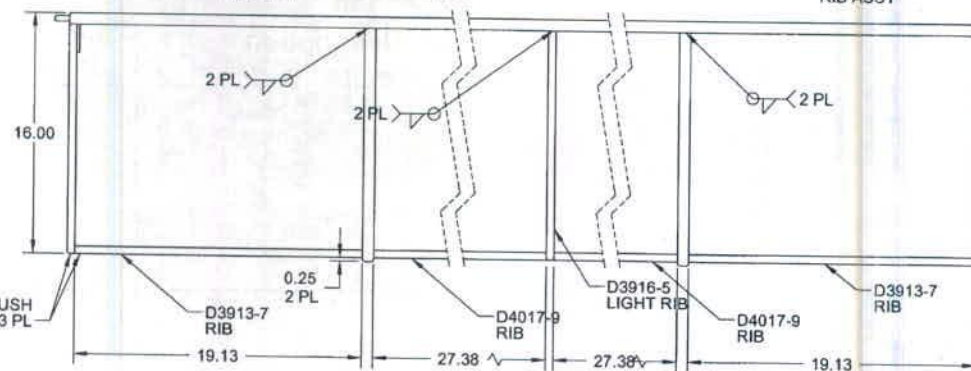
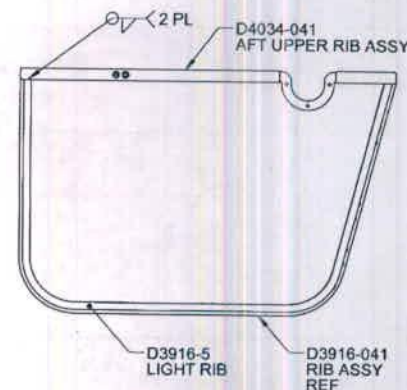
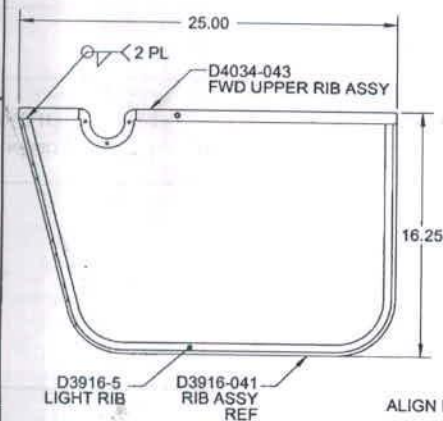
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



#57072



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.53 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
 - 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3913	SHEET 4 OF 8
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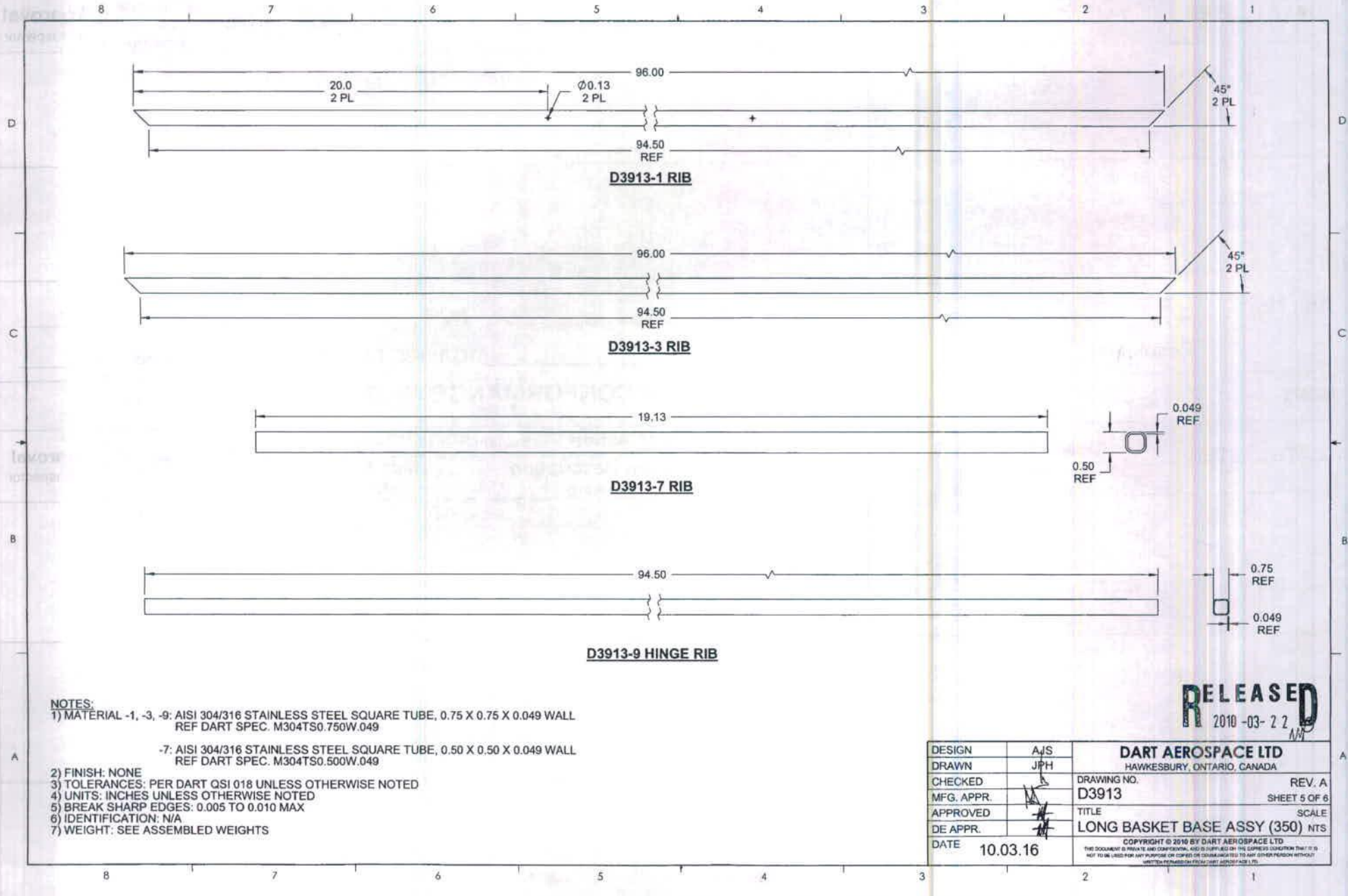
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#57070



NOTES:

- 1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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DESIGN	AJS	11/14	
DRAWN	JPH	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
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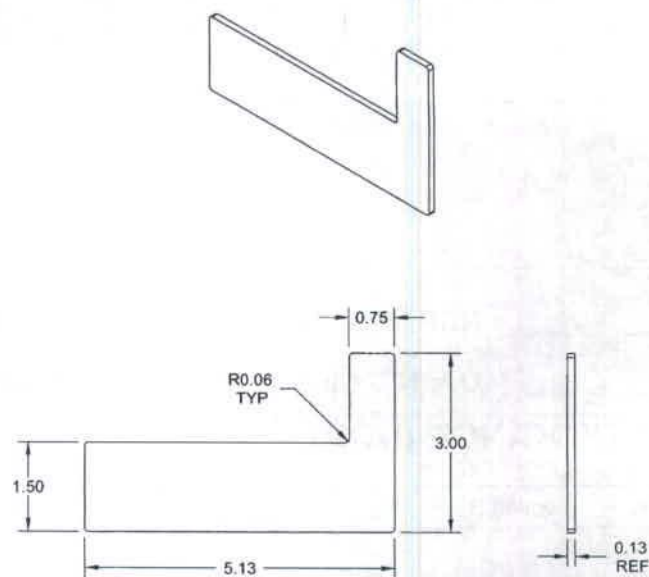
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries